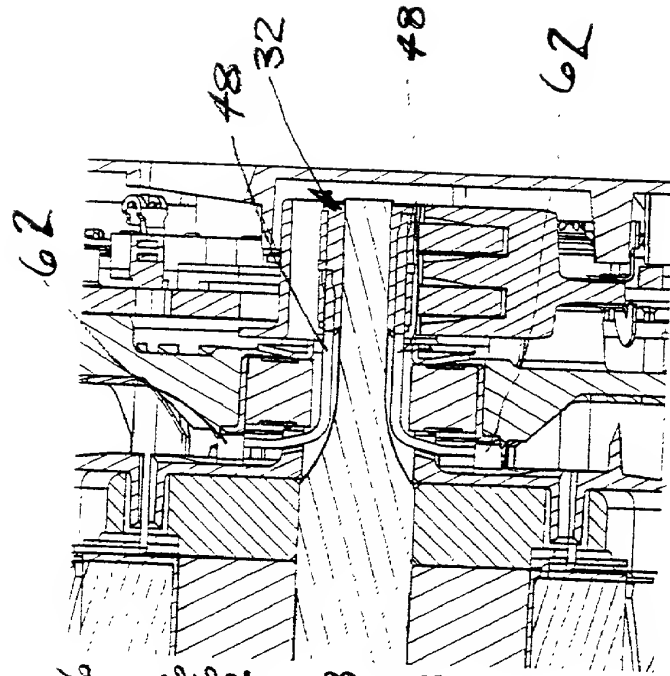


Simplified Cross-section  
view of alternator

Figure 1



Cross-section view of  
Rear components of alternator  
(showing Slip Ring and coil wires)

Figure 16

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24-22

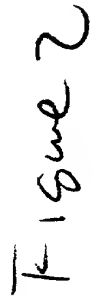
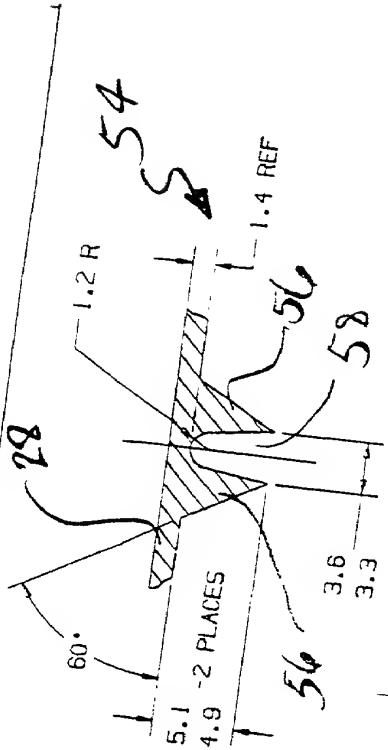


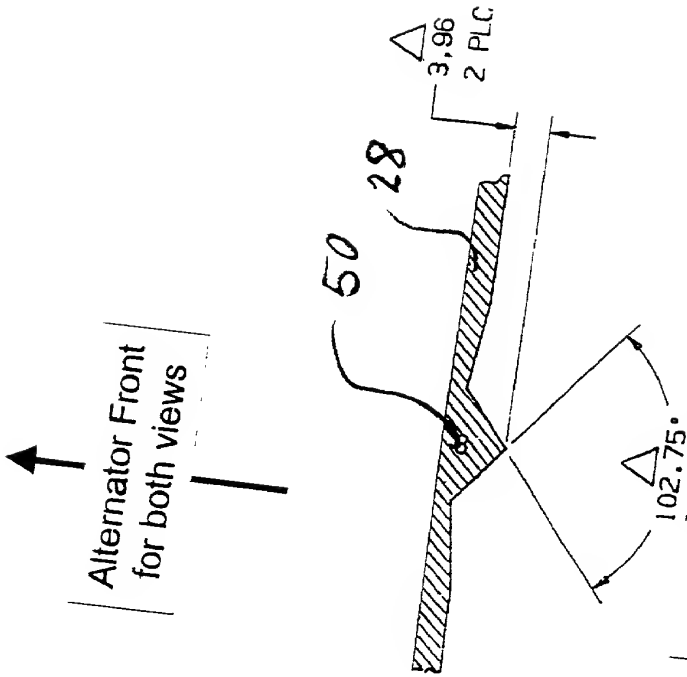
Figure 2

# Ultrasonically Welded Wire Retention Area for New Rotor



SRE (Rear) Fan  
Before U-S operation to hold  
wires on new rotor

Figure 3



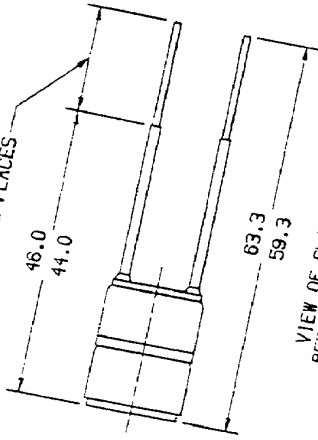
SRE (Rear) Fan  
After U-S operation to hold  
wires on new rotor

Figure 4

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# Alternator Slip Rings

STRIP LEAD FOR DISTANCE SHOWN - 2 PLACES



VIEW OF SLIP RING  
BEFORE FORMING LEADS

Figure 5

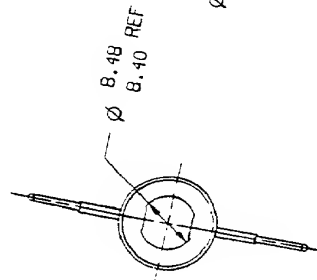


Figure 7

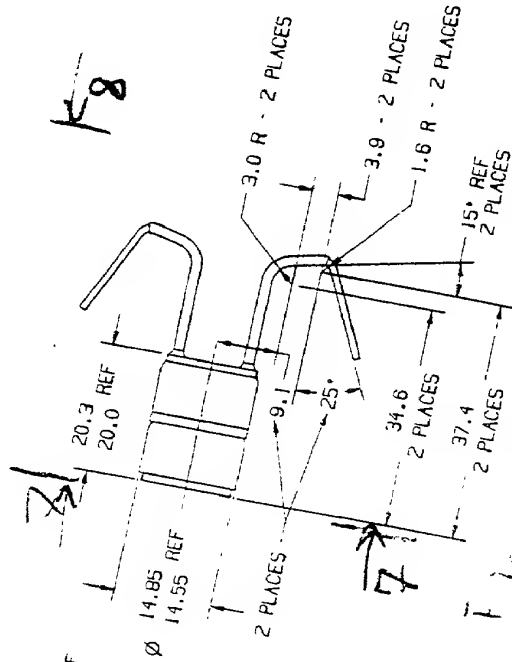


Figure 6

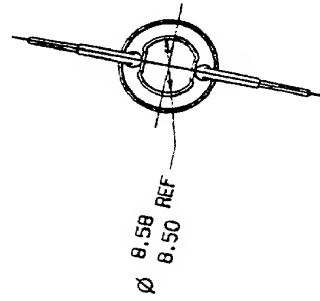
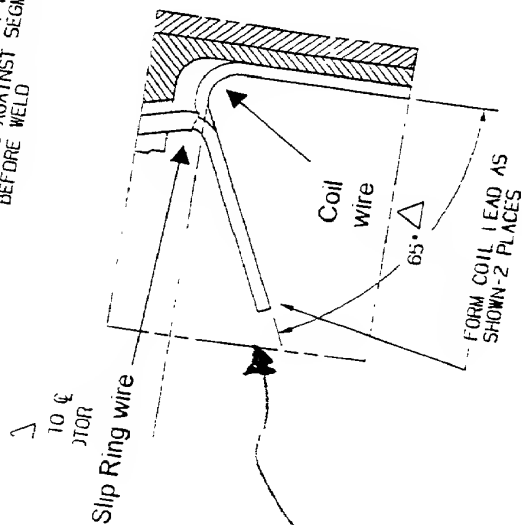


Figure 8

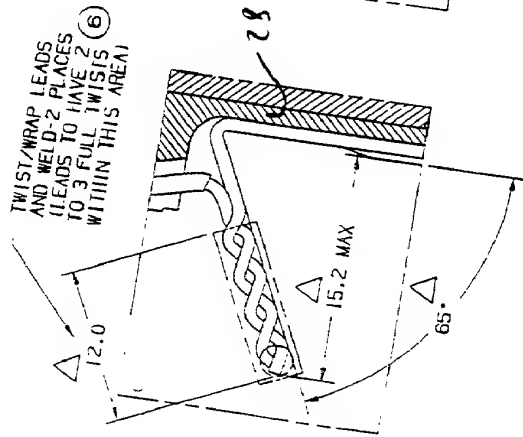
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# Views showing connection of Slip Ring & Coil

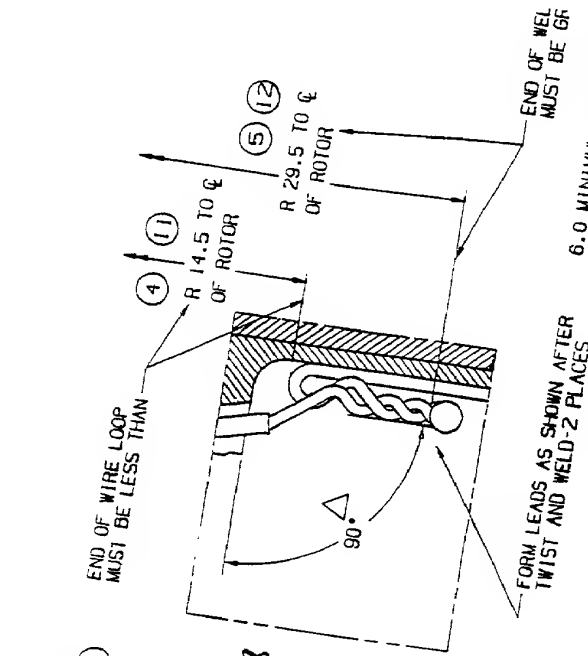
10475/54 FAN MUST BE SEATED AGAINST SEGMENT BEFORE WELD



Slip Ring and Coil wires formed, and lined up for twisting



Slip Ring and Coil wires twisted together



Slip Ring and Coil wires twisted, TIG welded (at tips), and folded flat against fan, ready for cap placement

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Figure 11

Figure 10

Figure 9

END OF WEL MUST BE GR  
6.0 MINIMUM SPACING BE  
DIAMETER FOR SRE AND C  
SURFACE IRREGULARITIES

FORM LEADS AS SHOWN AFTER  
TWIST AND WELD-2 PLACES

END OF WIRE LOOP  
MUST BE LESS THAN

R 14.5 TO  $\phi$   
OF ROTOR  
R 29.5 TO  $\phi$   
OF ROTOR

TWIST/WRAP LEADS  
(LEADS TO HAVE 2 (6)  
TO 3 FULL TWISTS  
WITHIN THIS AREA)

12.0

15.2 MAX

65°

90°

# Alternator Rotor Repair Cap

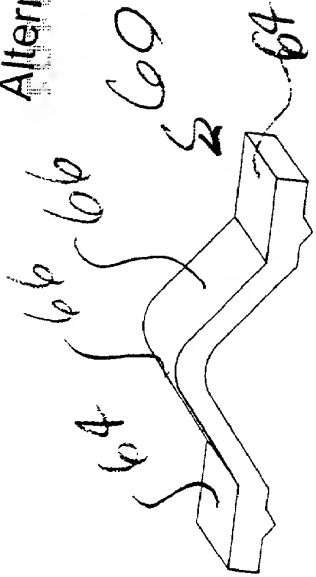


Figure 12

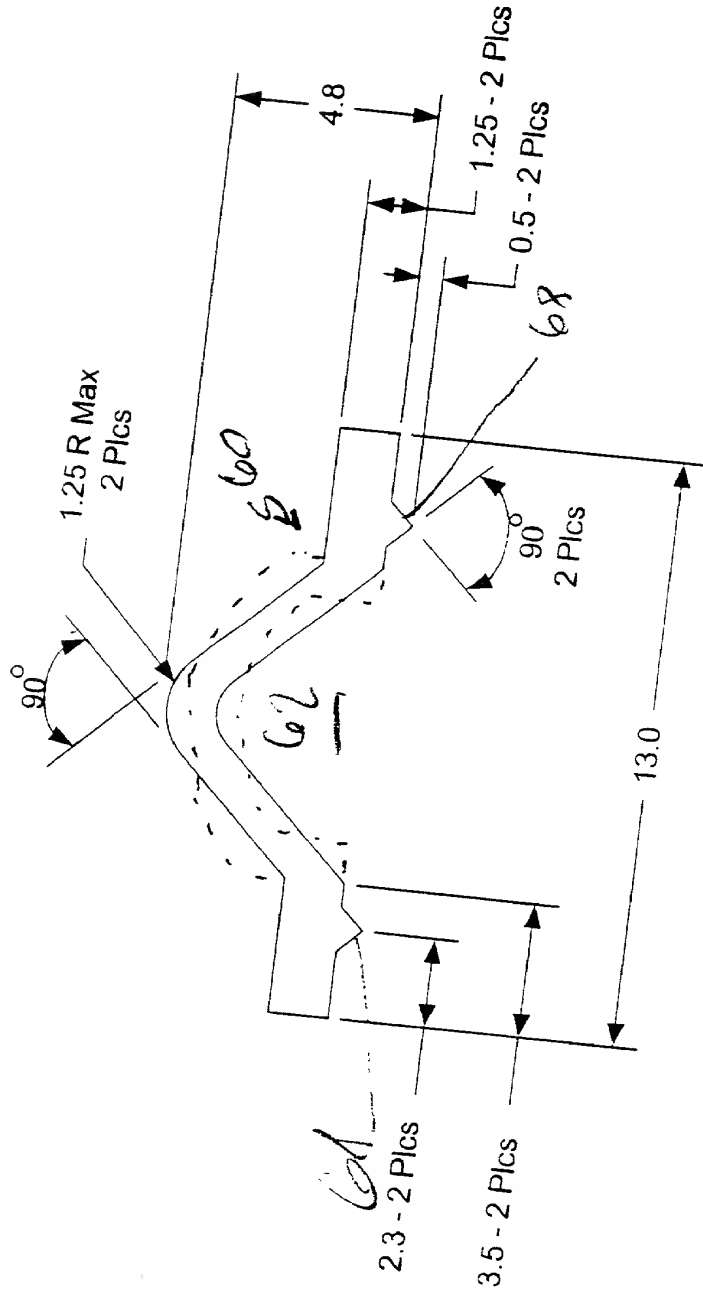


Figure 13

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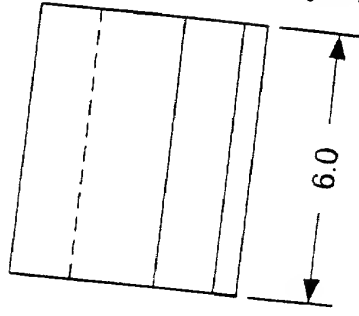


Figure 14

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View of New Rotor  
from rear

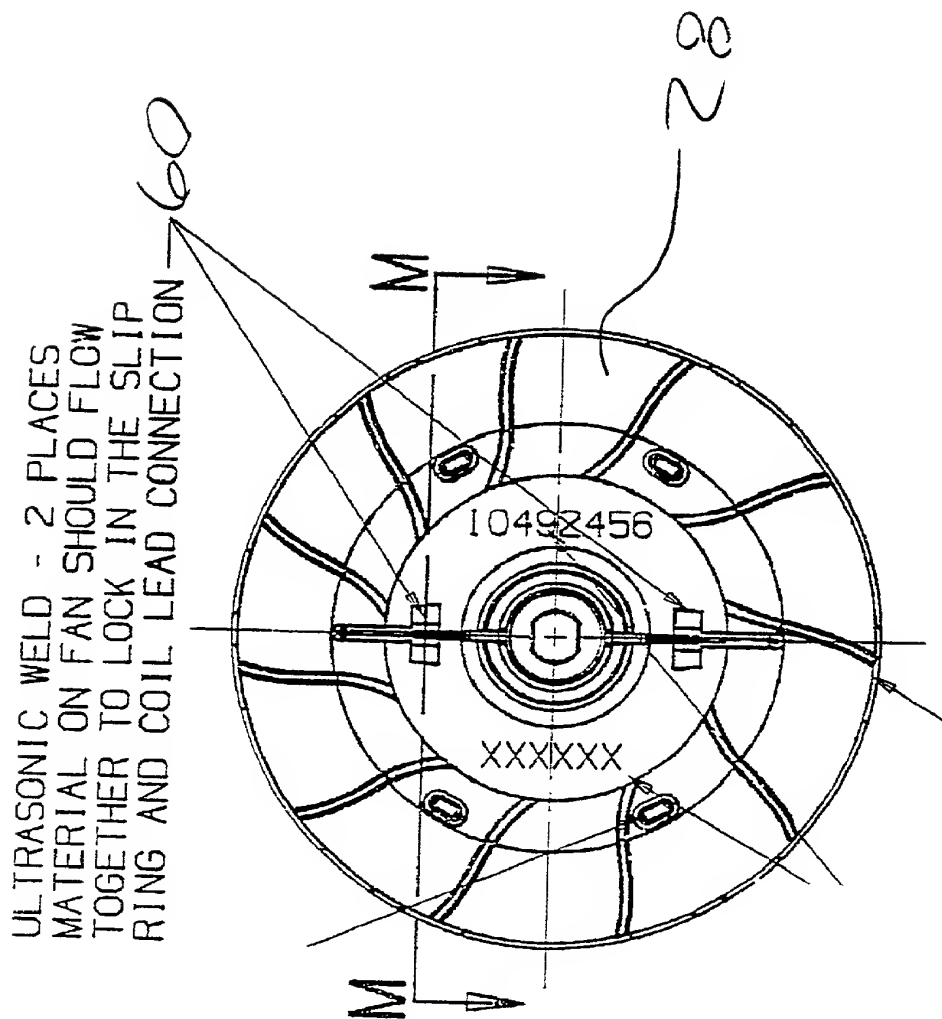


Figure 15

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Figure 17

